












Date: Thursday, 11/12/2008 10:08:17 AM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : WEARSHOE
<b>Job Number</b> : 43991	
<b>Estimate Number</b> : 10613	
<b>P.O. Number</b> :	<b>Part Number</b> : D265615
<b>This Issue</b> : 11/12/2008 <b>S.O. No.</b> :	<b>Drawing Number</b> : D2656 REV D
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : // <b>Type</b> : PURCHASED PARTS	<b>Drawing Revision</b> : D
<b>Previous Run</b> : 41125	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 22/12/2008 <b>Qty:</b> 10 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>JLD 08.12.11</u>	
<b>Comment</b> : Est: D 02.10.25 Re-format KJ Est Rev:E Now on Waterjet 06-09-25 JLM	
<b>Additional Product</b>	
Job Number: 	
<b>Seq. #:</b>	<b>Machine Or Operation:</b>
<b>Description :</b>	
1.0	M1010S20GA 1010/1025 SHEET
	
	
<b>Comment:</b> Qty.: 0.6431 sf(s)/Unit Total: 6.4313 sf(s) 1010/1025/A21/6aA SHEET (.040") (M1010S20GA) Batch: <u>109289</u> <u>HB 8-12-18</u>	
2.0	WATER JET FLOW WATER JET
	
	
<b>Comment:</b> FLOW WATER JET 1-Cut as per Dwg D2656 Dwg Rev: <u>D</u> <u>HB 8-12-18</u> Prog Rev: <u>D</u> 2-Deburr if necessary <u>HB 8-12-18</u>	
3.0	QC2 INSPECT PARTS AS THEY COME OFF MACHINE
	
	
<b>Comment:</b> INSPECT PARTS AS THEY COME OFF MACHINE	
4.0	QC8 SECOND CHECK
	
	
<b>Comment:</b> SECOND CHECK <u>S 08/12/16</u> <u>(12)</u>	
5.0	BRAKE NC NC BRAKE
	
	
<b>Comment:</b> NC BRAKE 1-Form on Brake as per Dwg D2656 using Jigs DT8261 and DT8326 2-Form joggle as per Dwg D2656 using Jig DT8158 3-Identify as D2656-15 <u>08/12/16</u> <u>(12)</u>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Thursday, 11/12/2008 10:08:17 AM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 43991

Part Number: D265615

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 02/01/05 (12)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME:

2:35

OVEN TEMPERATURE:

320°

FINISH TIME:

3:05

FL 09/01/05 (12)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-06-01 (12)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FP-20

08-06-01 (12)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/01/07

Job Completion



MF 08-01-06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	43991
<b>Description:</b> Wearshoe		<b>Part Number:</b>	D2656-15
<b>Inspection Dwg:</b> D2656	<b>Rev:</b> D	<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
39.150	+/-0.010	39.150	X			
35.650	+/-0.010	35.650	X			
33.650	+/-0.010	33.650	X			
30.150	+/-0.010	30.150	X			
24.900	+/-0.010	24.900	X			
19.650	+/-0.010	19.650	X			
14.400	+/-0.010	14.400	X			
9.150	+/-0.010	9.148	X			
5.650	+/-0.010	5.647	X			
2.000	+/-0.010	2.000	X			
1.885	+/-0.010	1.888	X			
0.300	+/-0.010	0.303	X			
0.300	+/-0.010	0.301	X			
0.040	+/-0.010	0.034	X			

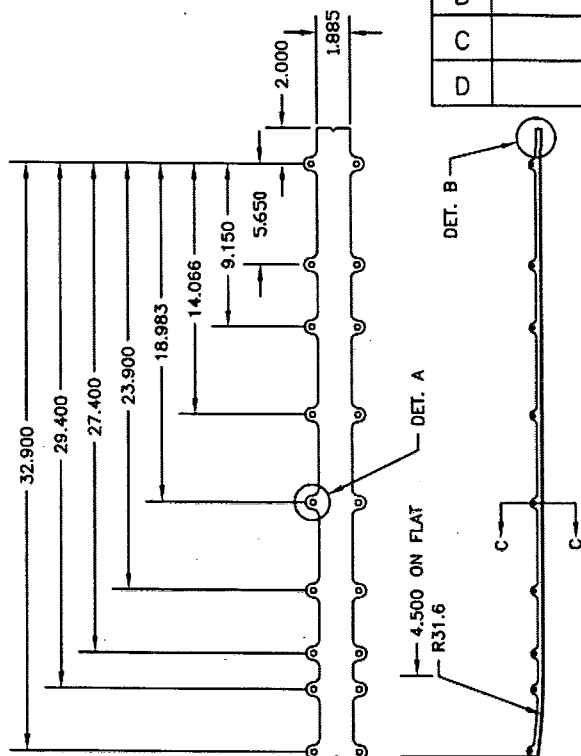
<b>Measured by:</b> B	<b>Audited by:</b> S	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 8-12-18	<b>Date:</b> 08/12/18	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	07.07.18	New Issue	KJ/JLM	B

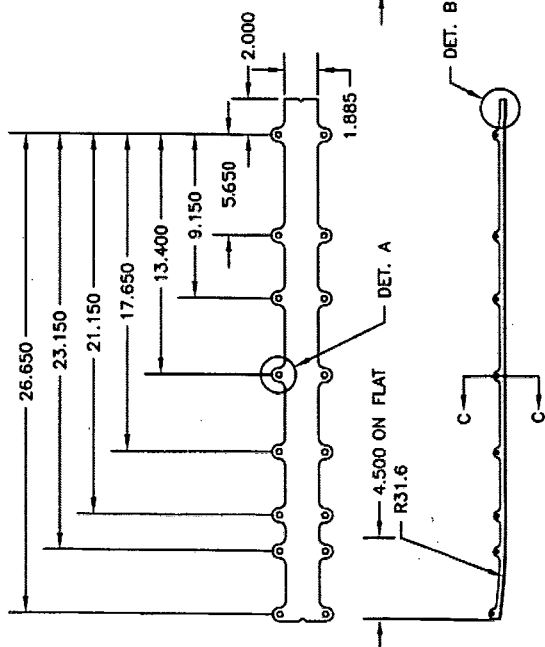


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				D2656	SHEET 1 OF 4
DATE	05.08.17			TITLE	SCALE
				WEARSHOE	1:10
A	97:03:25	NEW ISSUE			
B	97:06:02	CHANGED TABS			
C	97:06:26	R31.6 WAS R19.5			
D	05.08.17	ENLARGE ALL HOLES TO IMPROVE FIT			

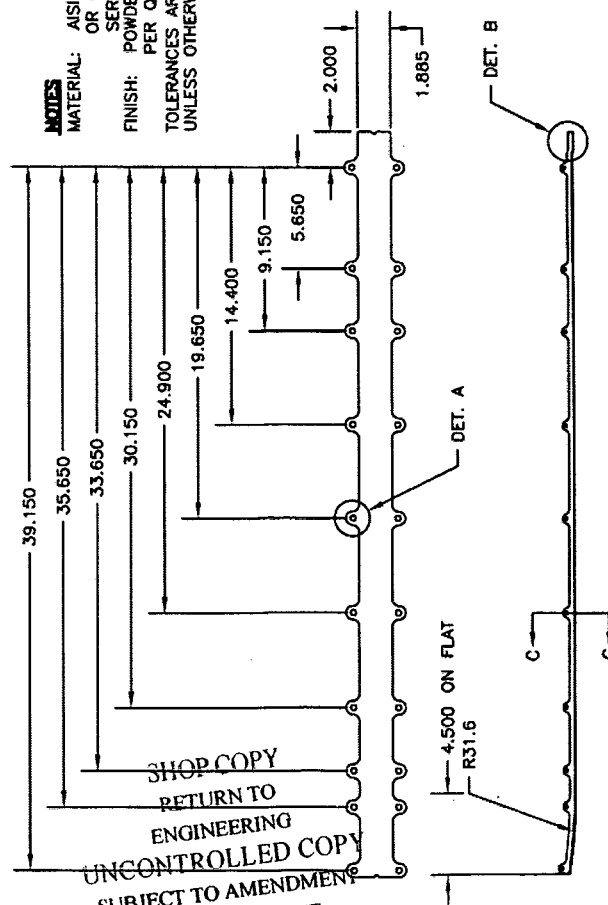
D2656-13



D2656-11



D2656-15



**NOTES**  
 MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008  
 OR CSA G40-21, 38W/44W/50W/60W/70W  
 SERIES STEEL, 20 GAUGE (0.040 THICK)  
 FINISH: POWDER COAT GREY SANDTEX (4.3.5.6)  
 PER QSI 005 4.3  
 TOLERANCES ARE PER DART QSI 018  
 UNLESS OTHERWISE NOTED

RELEASED  
 05.09.08

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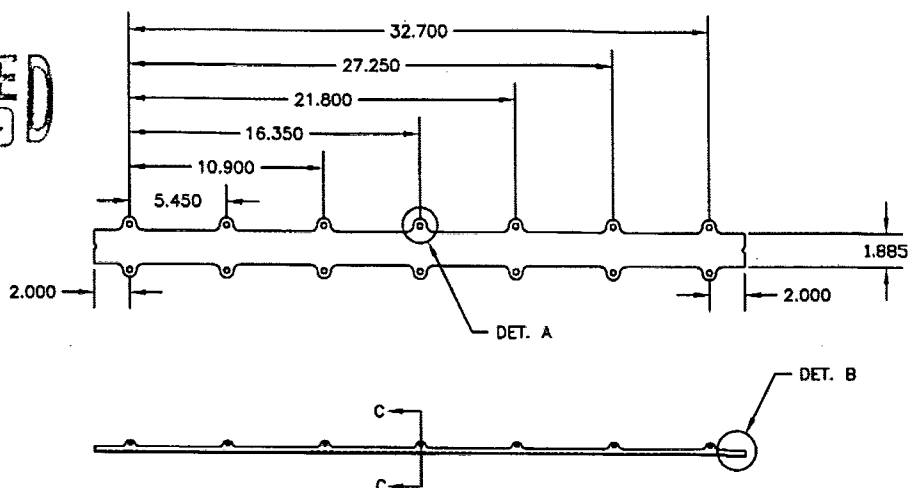
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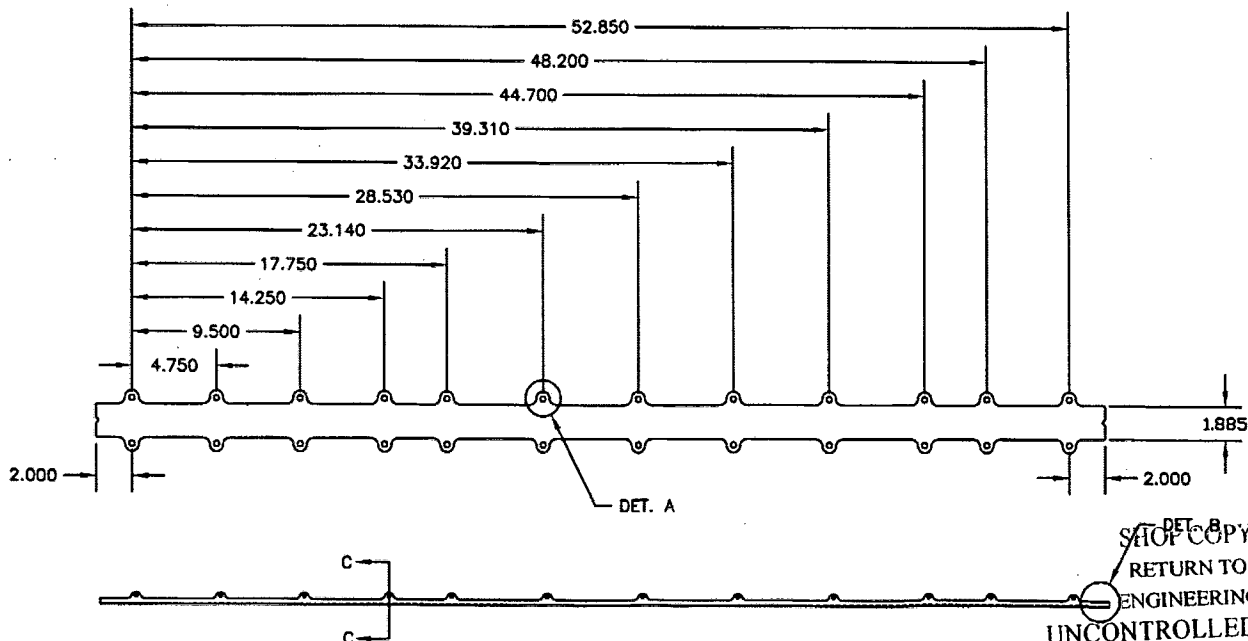
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DATE 05.08.17	TITLE WEARSHOE		SCALE 1:10

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05.01.06

### D2656-21



### D2656-23



#### NOTES

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W  
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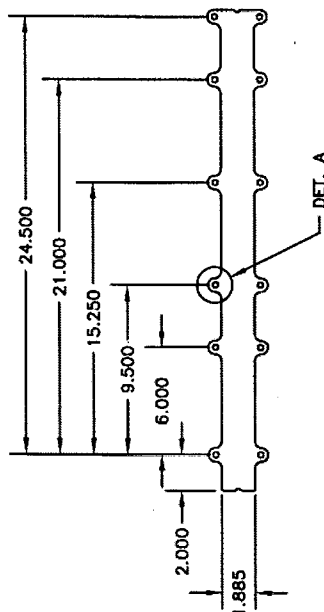
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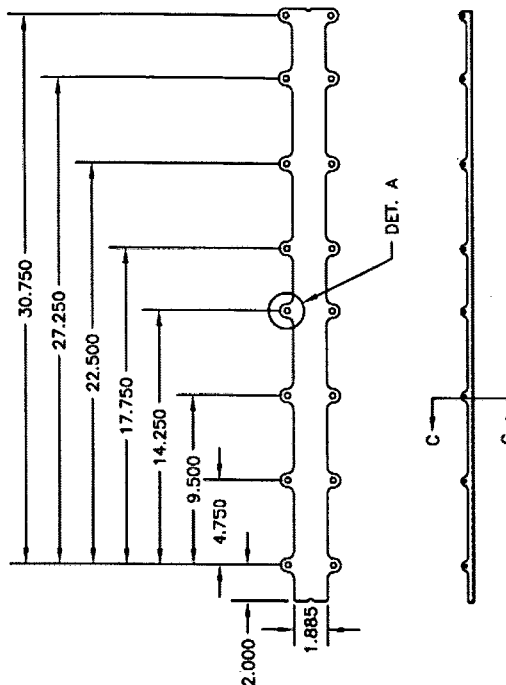


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DATE 05.08.17		TITLE WEARSHOE	SCALE 1:10

D2656-33

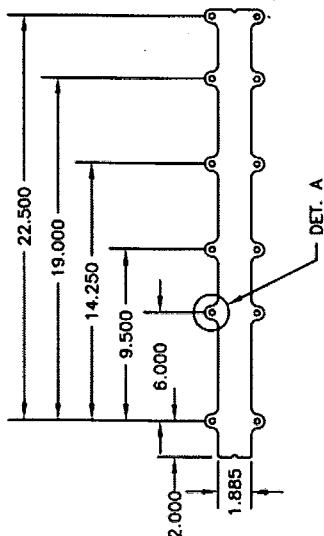


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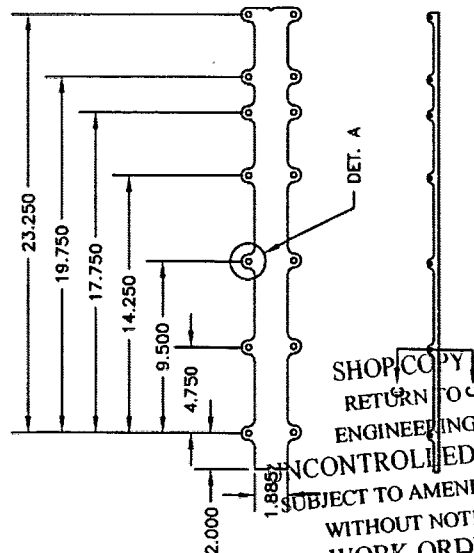


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D2656-35



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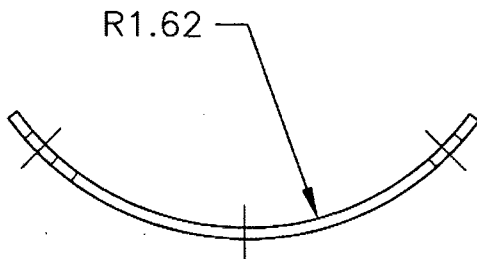
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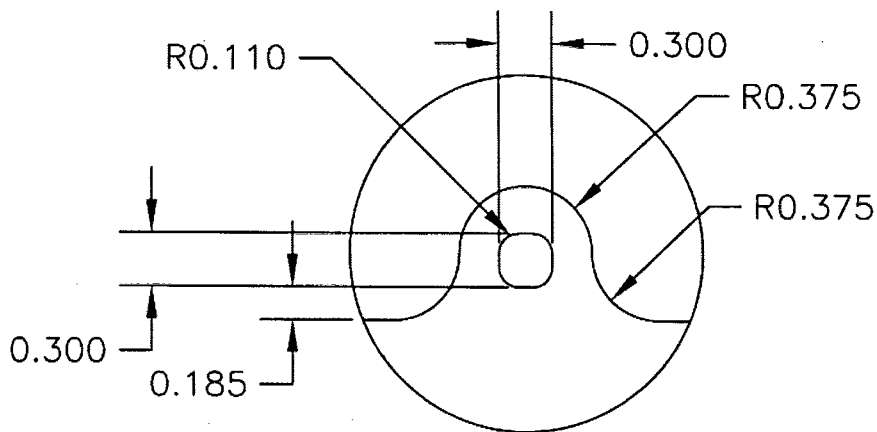
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DATE 05.08.17	TITLE WEARSHOE		SCALE 1:10

### SECTION C-C

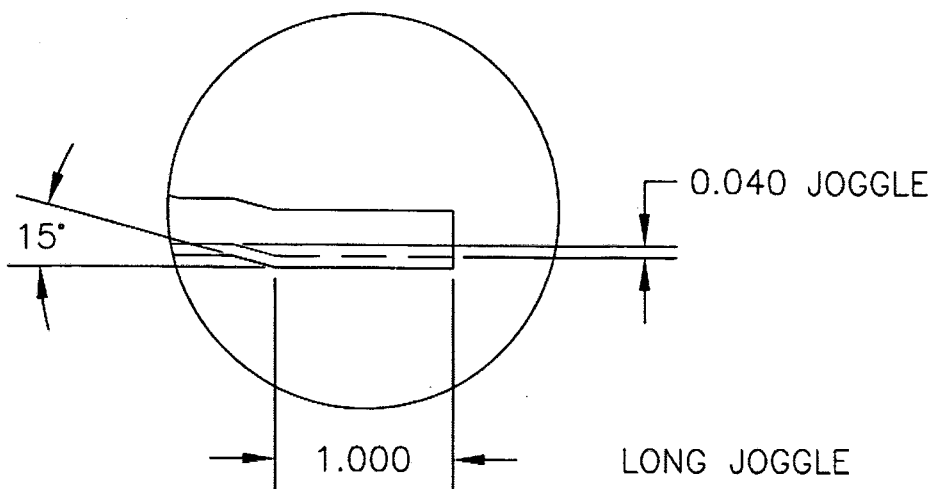


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### DETAIL A



### DETAIL B



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